

Work Order ID 92955-1

November-12-12 1:36:39 PM

SPLIT-1

92955

HAI

Page 1

Item ID: D4635-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Ceiling Panel, LII

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

MLS

Date: 12-11-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4635

A B Wh. 12/03/02

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x2

DAS
07
12/12/04

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 7:00 pm

Time OUT: 7:00 am

12/12/03
12/12/04

x2

DAS
07
12/12/04

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Work Order ID 92955

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92955

Page 2

Item ID: D4635-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Ceiling Panel, LH

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4635-1 and Folio FTA147

Dwg. Rev. A

Folio Rev. A

Visually inspect for proper formation and texture

x2

12/12/04

130

0.00

130

Thermoform

HAND FINISHING THERMOFORMING

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

140

0.00

140

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 92955

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92955

Page 3

Item ID: D4635-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Ceiling Panel, L11

Stop ***NS2***

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

1AA1 MF
13-2-25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

November-12-12 1:36:43 PM

Page 1

Work Order ID: 92955

92955

Parent Item: D4635-1

D4635-1

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	13.36	29.68889			

MKYD6185S 080-P3-62015

6185 KYDEX .080"

**

Location

Loc Qty

Loc Code

therm

1028.362377

116576

14.148377

121755

1014.214

Dh
12/12/10

29.6959 ft

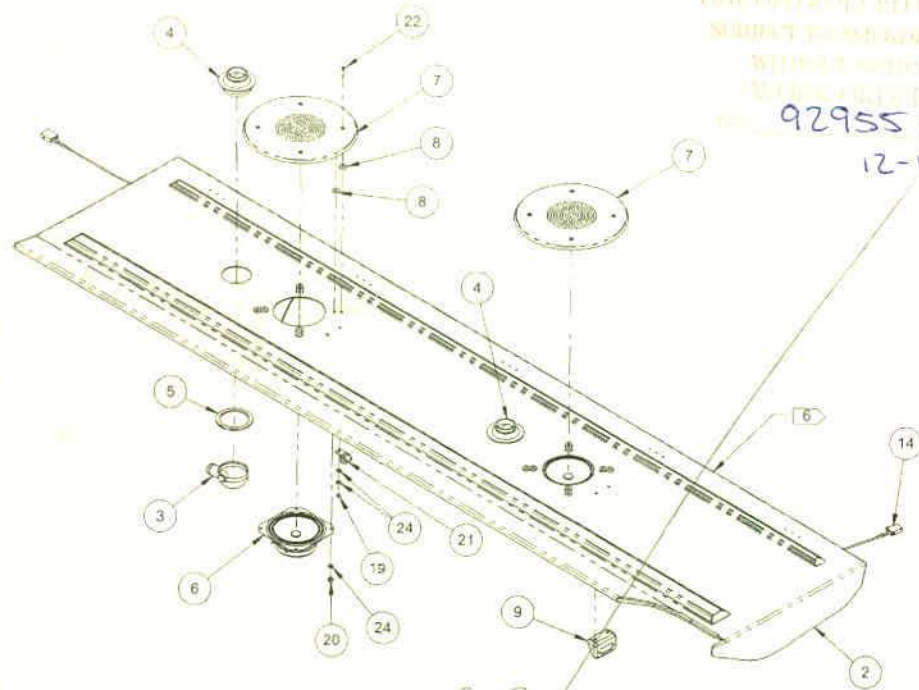
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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92955 MLT
12-11-12

D4635-041 LH, FWD CEILING PANEL ASSY

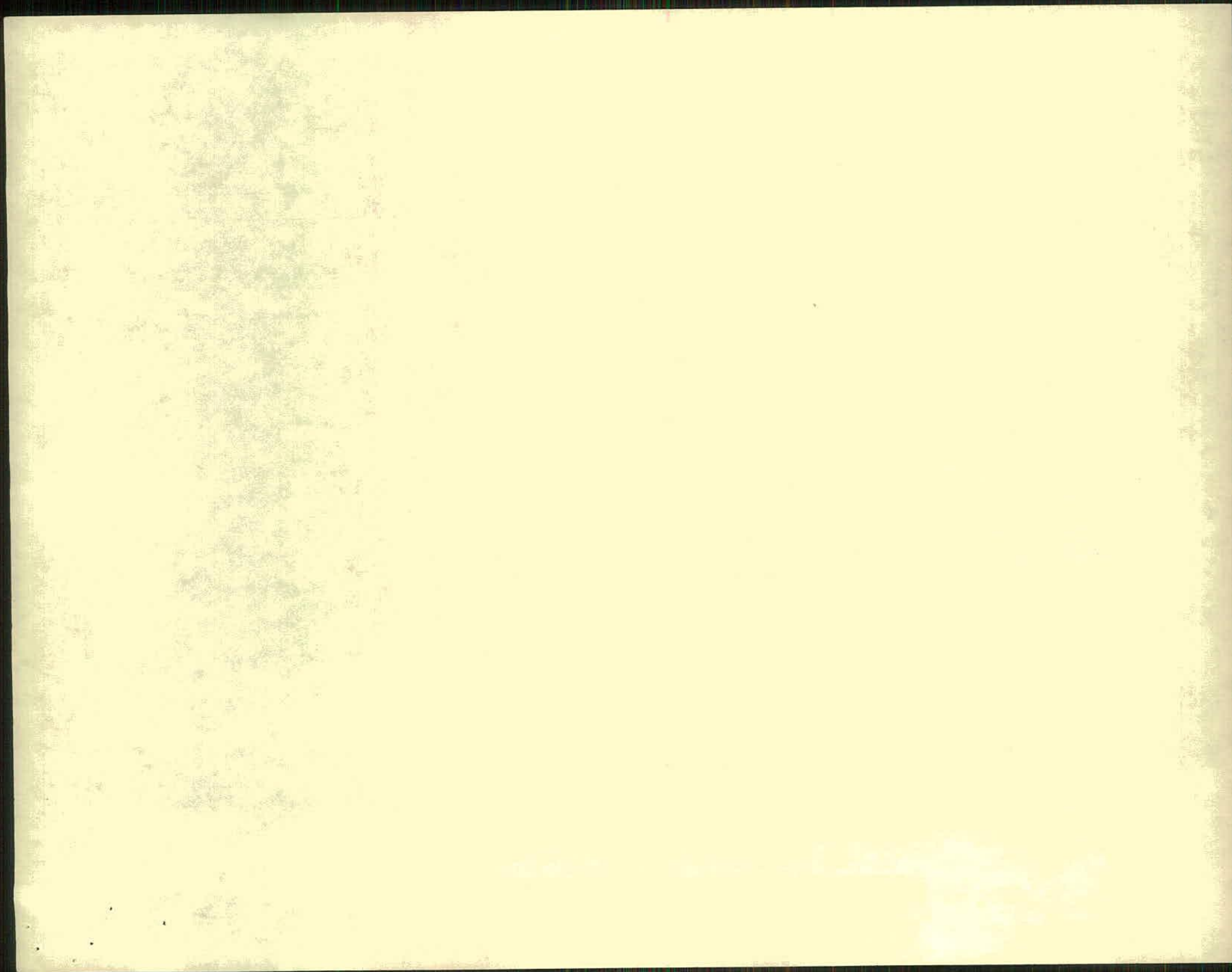
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.8 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4669-1, D4695-041 & PLT1.5M-M, WAIT FOR 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) INSTALL D4728-041/043/059 WIRE HARNESS PER QSI 048
- 11) ALIGN THE LONGITUDINAL BEND IN D4695-041 CHANNEL ASSEMBLY WITH THE BEND ON D4635-1 PANEL & CENTER D4695-041 BETWEEN BOTH ENDS OF D4635-1
- 12) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

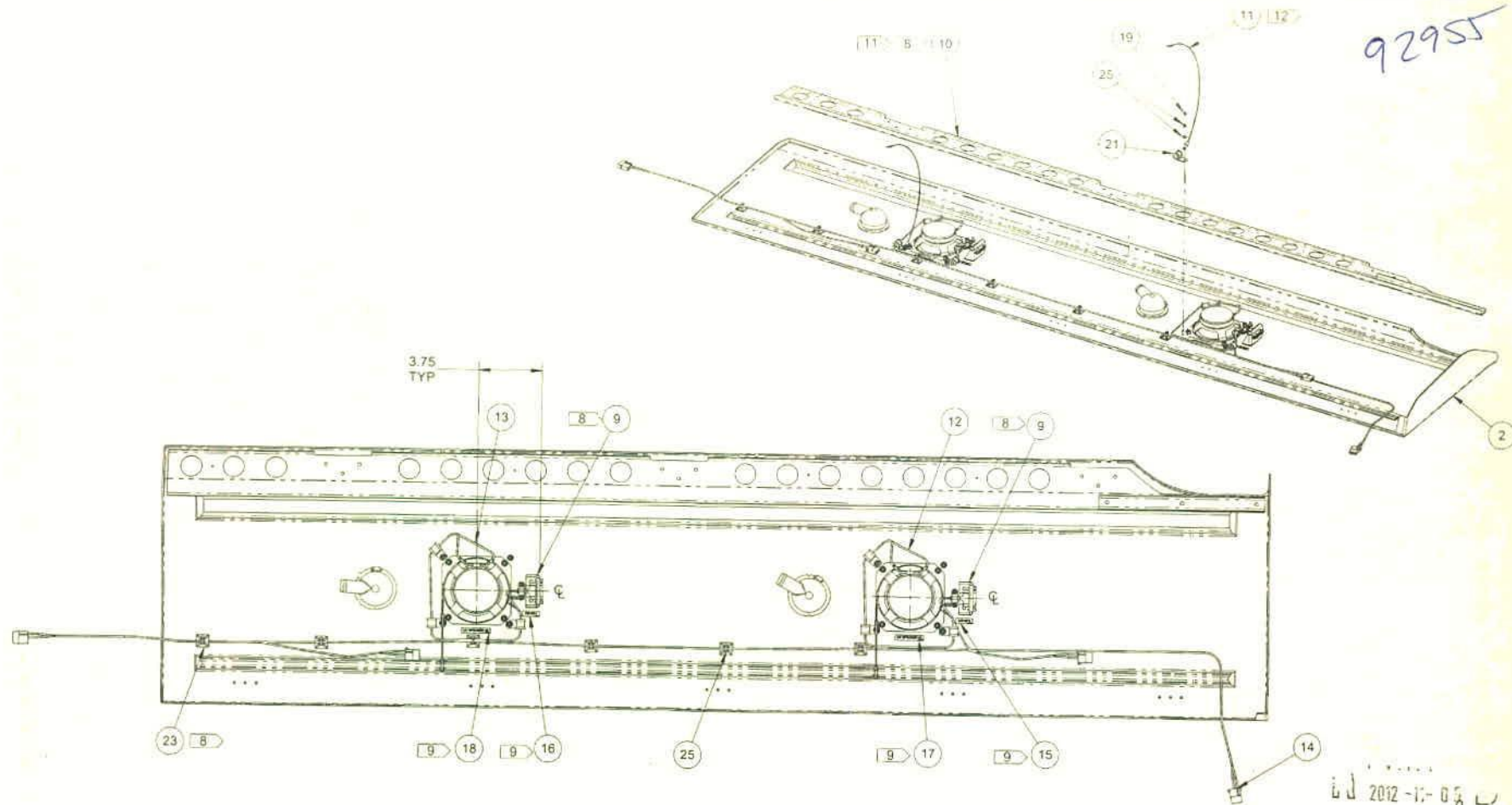
ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-1	LH, FWD CEILING PANEL
3	2	D4640-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2		AIR VALVE NUT
6	2	D4655-1	SPEAKER
7	2	D4655-3	SPEAKER GRILL
8	16	D4664-3	SPACER
9	2	D4669-1	BRACKET
10	1	D4695-041	LH CHANNEL ASSEMBLY
11	2	D4708-9	LANYARD
12	1	D4728-041	LH SPEAKER #1 HARNESS ASSEMBLY
13	1	D4728-043	LH SPEAKER #2 HARNESS ASSEMBLY
14	1	D4728-059	CABIN LIGHT HARNESS
15	1	D4732-5	LABEL
16	1	D4732-9	LABEL
17	1	D4732-29	LABEL
18	1	D4732-33	LABEL
19	8	MS21042L08	NUT
20	8	MS21044-N08	NUT
21	6	MS21919WDG8	CLAMP
22	8	MS24694-S7	SCREW
23	6	MPNY-750S-9-C	MOUNTING PAD
24	24	NAS1149DN832J	WASHER
25	6	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

2012-11-05

A NEW ISSUE		RF	12.07.25
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4635 REV. A SHEET 1 OF 14 TITLE OUTBOARD CEILING PANELS SCALE NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DATE 12.07.25 COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



92955

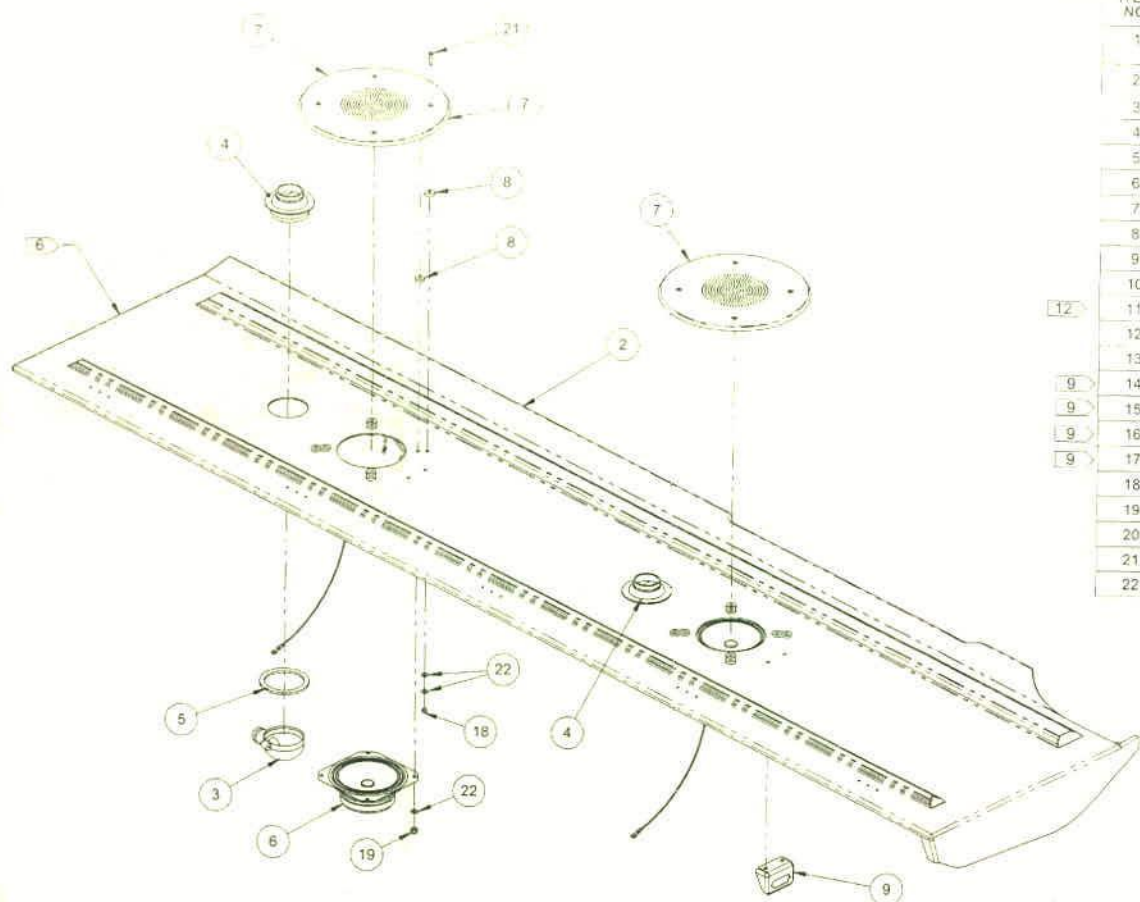


D4635-041 LH, FWD CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 2 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-2	RH, FWD CEILING PANEL
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	-	AIR VALVE NUT
6	2	D4655-1	SPEAKER
7	2	D4655-3	SPEAKER GRILL
8	16	D4664-3	SPACER
9	2	D4669-1	BRACKET
10	1	D4695-042	RH CHANNEL ASSEMBLY
11	2	D4708-9	LANYARD
12	1	D4728-042	RH SPEAKER #3 HARNESS ASSEMBLY
13	1	D4728-044	RH SPEAKER #2 HARNESS ASSEMBLY
14	1	D4732-3	LABEL
15	1	D4732-7	LABEL
16	1	D4732-31	LABEL
17	1	D4732-35	LABEL
18	8	MS21042L08	NUT
19	8	MS21044-N08	NUT
20	6	MS21919WDG8	CLAMP
21	8	MS24694-S7	SCREW
22	24	NAS1149DN832J	WASHER

NOTES:

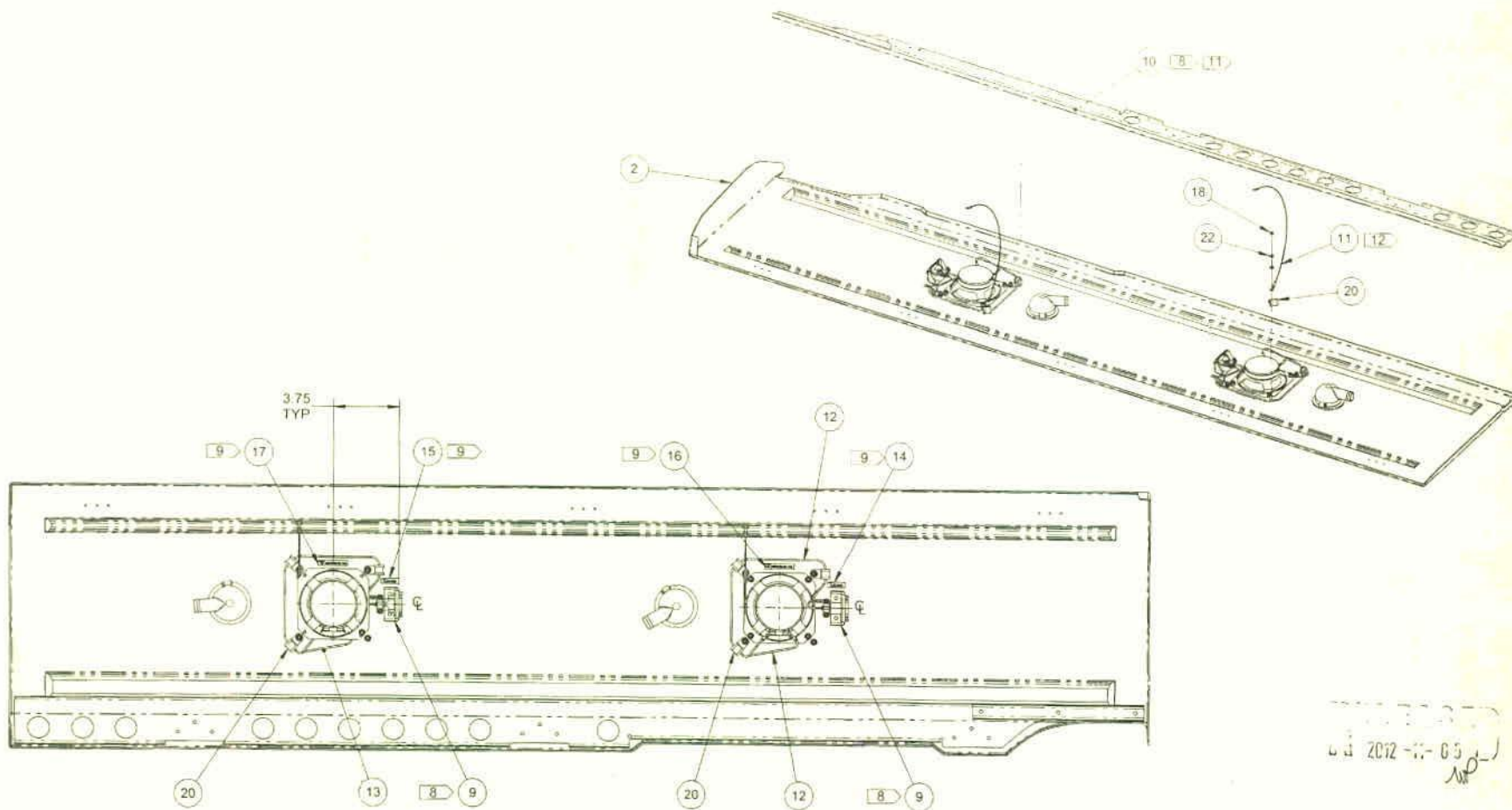
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.8 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04) THICK TO BOND D4669-1 & D4695-042, WAIT 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) INSTALL D4728-042/-044 WIRE HARNESS PER QSI 048
- 11) ALIGN THE LONGITUDINAL BEND IN D4695-042 CHANNEL ASSEMBLY WITH THE BEND ON D4635-2 PANEL & CENTER D4695-042 BETWEEN BOTH ENDS OF D4635-2
- 12) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

D4635-042 RH, FWD CEILING PANEL ASSY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4635	SHEET 3 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS	NTS
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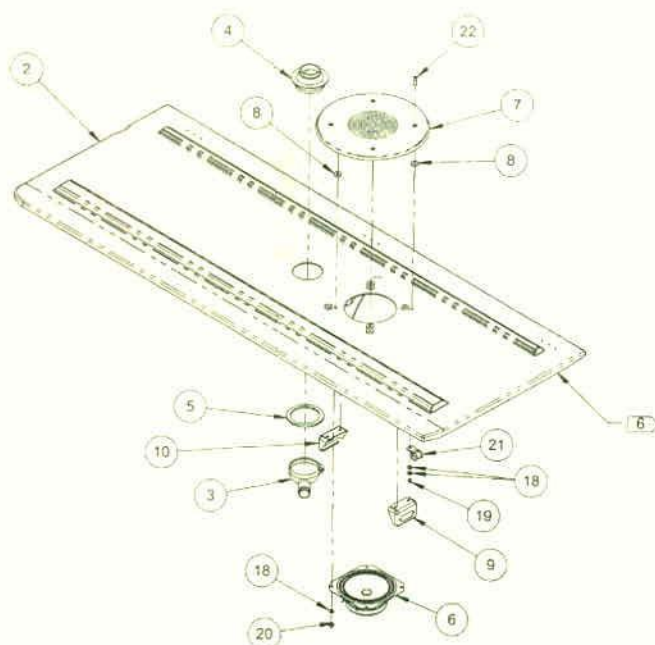


D4635-042 RH, FWD CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 4 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
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D4635-043 LH. AFT CEILING PANEL ASSY

NOTES:

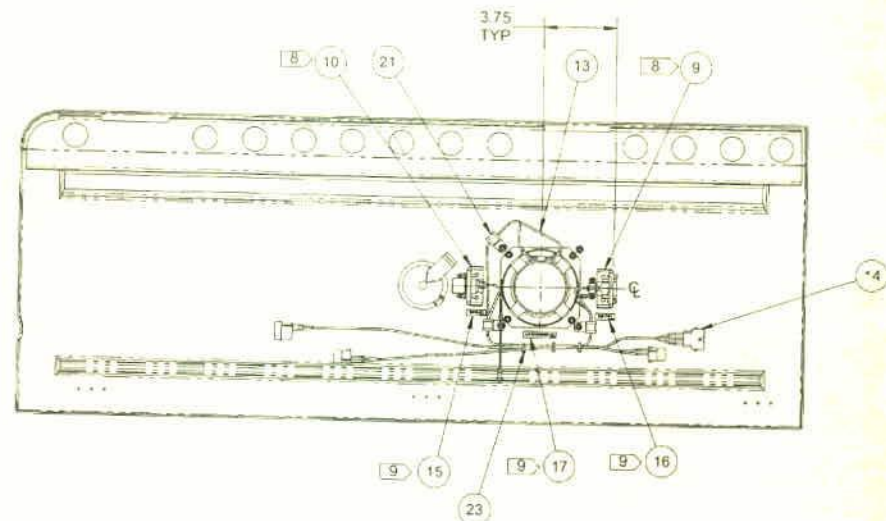
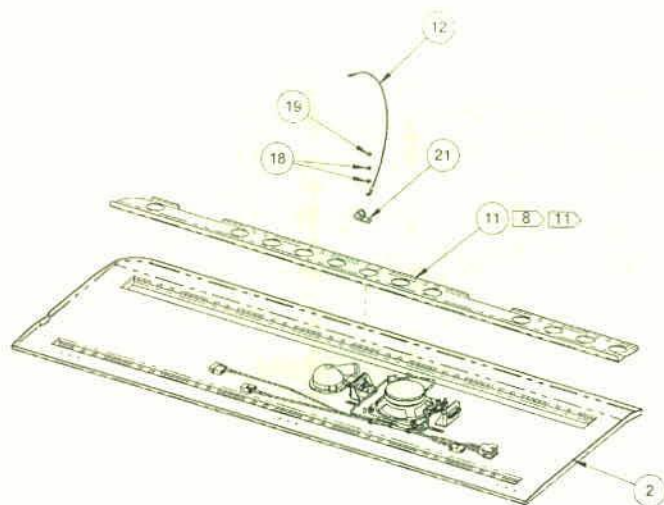
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04) THICK TO BOND D4669-1/-3, D4695-3 & PLT1.5M-M. WAIT 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) INSTALL D4728-045/-061 WIRE HARNESS PER QSI 048
- 11) ALIGN THE LONGITUDINAL BEND IN D4695-3 CHANNEL WITH THE BEND ON D4635-3 PANEL & CENTER D4695-3 BETWEEN BOTH ENDS OF D4635-3
- 12) ON D4708-9 LANYARD OPEN TO $\varnothing 0.196$ BOTH ENDS

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	X	D4635-043	LH. AFT CEILING PANEL ASSY
2	1	D4635-3	LH. AFT CEILING PANEL
3	1	D4646-1	FLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1		AIR VALVE NUT
6	1	D4655-1	SPEAKER
7	1	D4655-3	SPEAKER GRILL
8	8	D4664-3	SPACER
9	1	D4669-1	BRACKET
10	1	D4669-3	BRACKET
11	1	D4695-3	CHANNEL
12	1	D4708-9	LANYARD
13	1	D4728-045	LH SPEAKER #3 HARNESS ASSEMBLY
14	1	D4728-061	CABIN LIGHTS CONTROL RELAY HARNESS ASSEMBLY
15	1	D4732-1	LABEL
16	1	D4732-13	LABEL
17	1	D4732-37	LABEL
18	12	NAS1149DN832J	WASHER
19	4	MS21042L08	NUT
20	4	MS21044-N08	NUT
21	3	MS21919WDG8	CLAMP
22	4	MS24694-S7	SCREW
23	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4635	SHEET 5 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS NTS	
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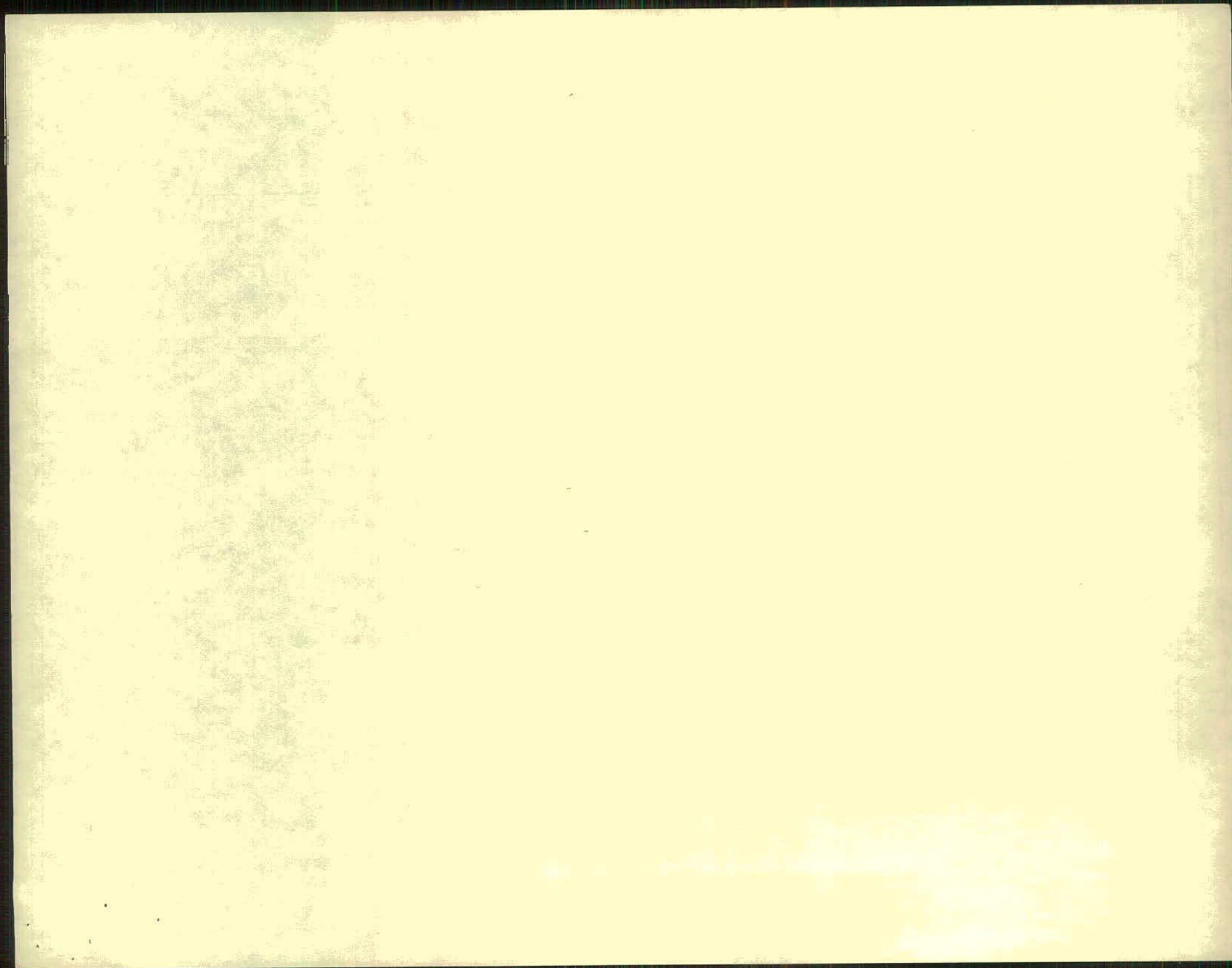
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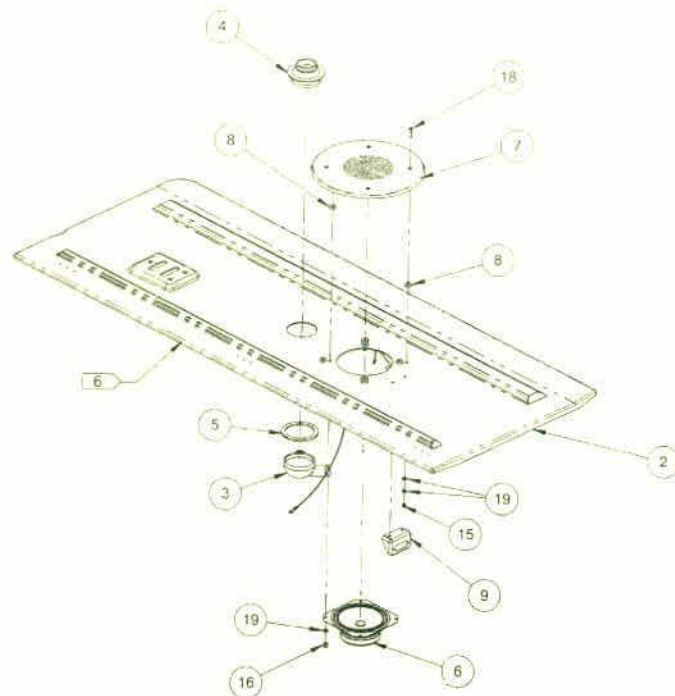
D4635-043 LH. AFT CEILING PANEL ASSY
AUXILIARY VIEW

2012-11-30
JH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 6 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
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ITEM NO	QTY	PART NUMBER	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-4	RH, AFT CEILING PANEL
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	-	AIR VALVE NUT
6	1	D4655-1	SPEAKER
7	1	D4655-3	SPEAKER GRILL
8	8	D4664-3	SPACER
9	1	D4669-1	BRACKET
10	1	D4695-4	CHANNEL
11	1	D4708-9	LANDYARD
12	1	D4728-046	RH SPEAKER #3 HARNESS ASSEMBLY
13	1	D4732-11	LABEL
14	1	D4732-39	LABEL
15	4	MS21042L08	NUT
16	4	MS21044-N08	NUT
17	3	MS21919WDG8	CLAMP
18	4	MS24694-S7	SCREW
19	12	NAS1149DN832J	WASHER

NOTES:

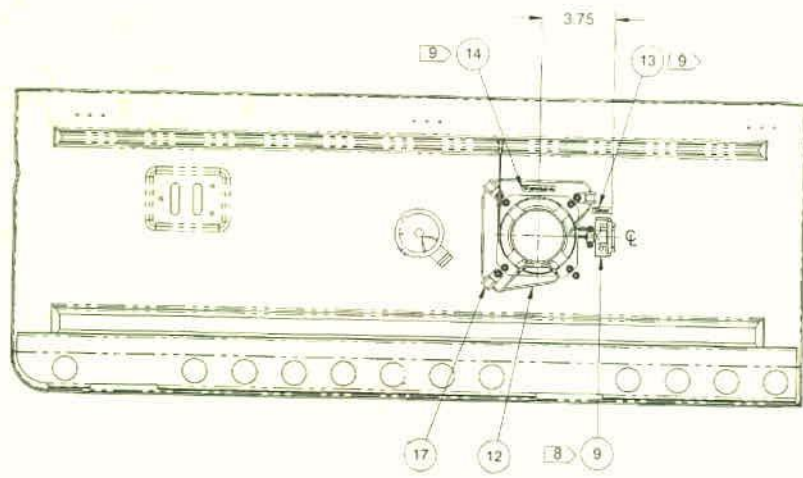
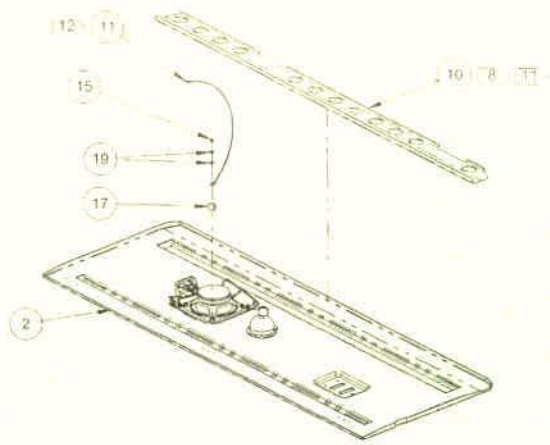
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04) THICK TO BOND D4669-1, D4695-4, WAIT 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 11) ALIGN THE LONGITUDINAL BEND IN D4695-4 CHANNEL WITH THE BEND ON D4635-4 PANEL & CENTER D4695-4 BETWEEN BOTH ENDS OF D4635-4
- 12) ON D4708-9 LANYARD OPEN TO $\varnothing 0.196$ BOTH ENDS

D4635-044 RH, AFT CEILING PANEL ASSY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4635	SHEET 7 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS	
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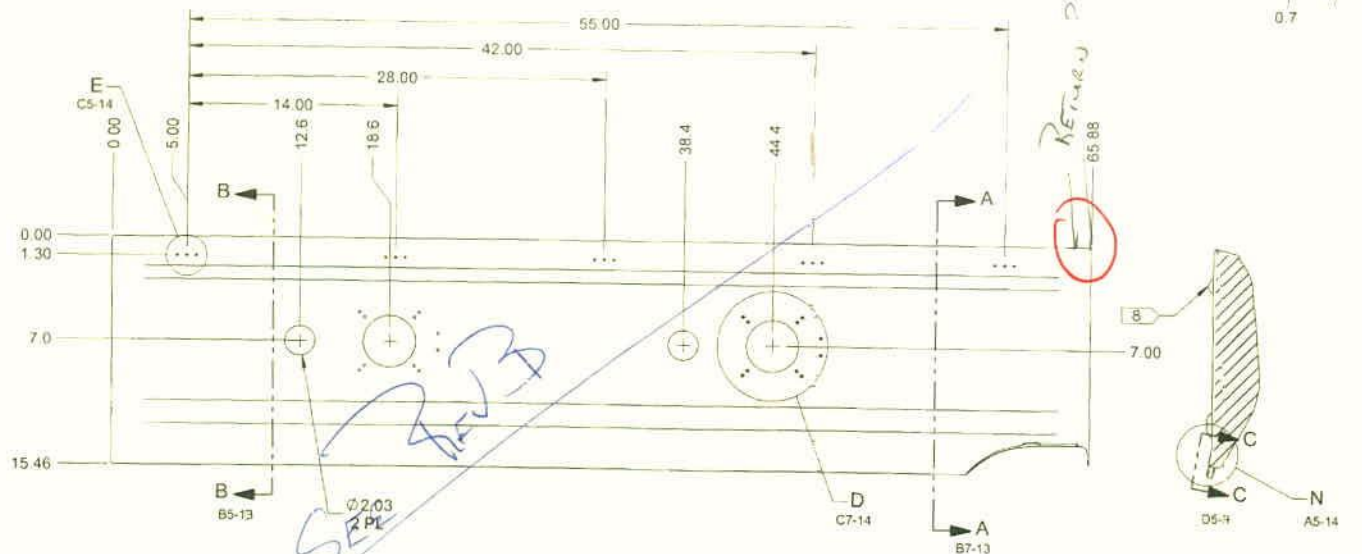
D4635-044 RH. AFT CEILING PANEL ASSY
AUXILIARY VIEW

2012-11-08
JMP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 3 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
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VIEW C-C B2-9



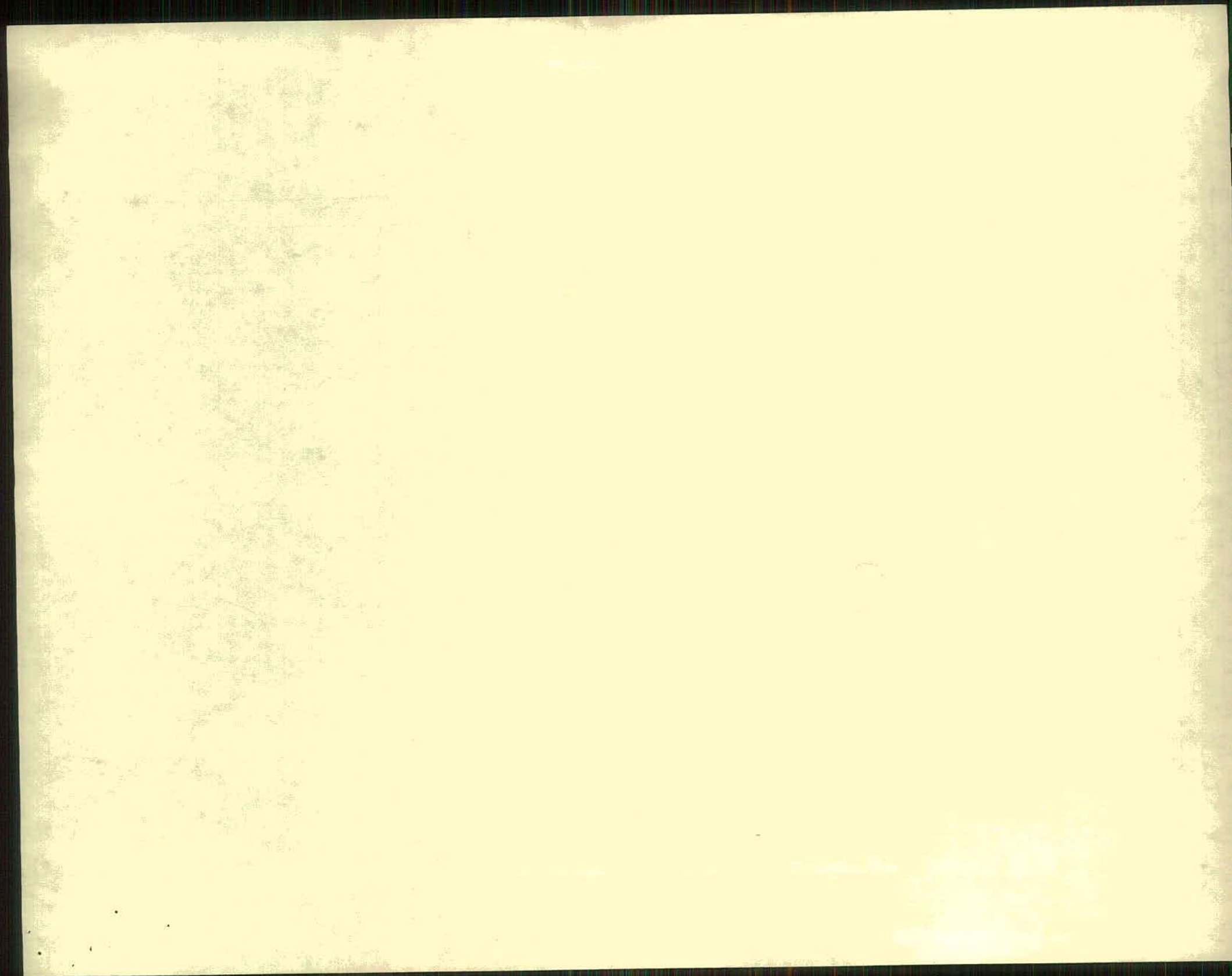
1) MATERIAL KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.29 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

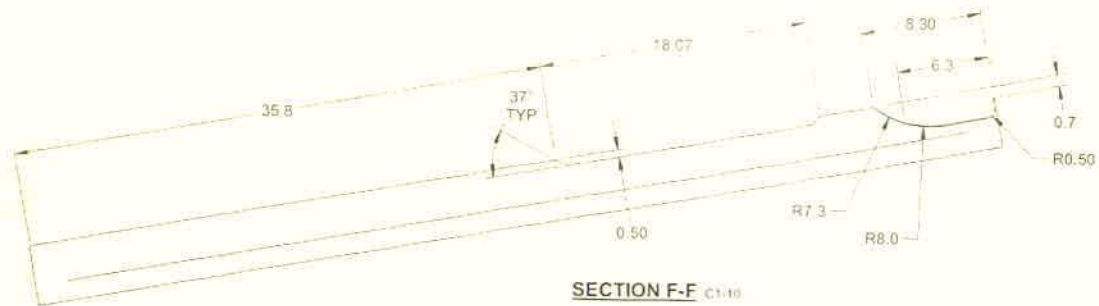
D4635-1 LH, FWD CEILING PANEL

2012-11-05

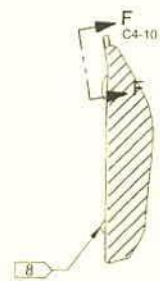
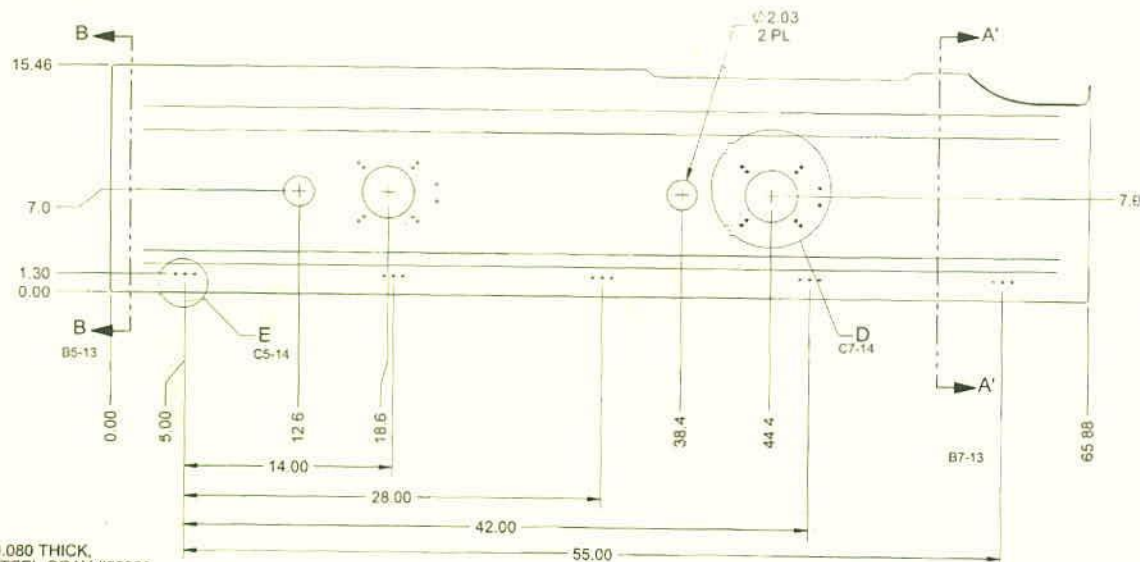
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 09 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS NTS	
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92955



SECTION F-F C1-10



NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.28 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-2 PER TOOL DT9840
- 10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-2 RH, FWD CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 10 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
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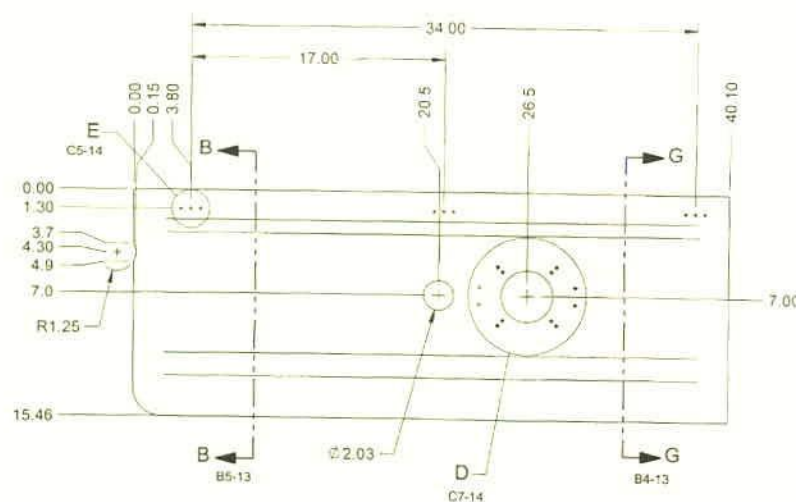
1405 717 1277 402



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SECTION H-H B2-11



D4635-3 LH, AFT CEILING PANEL

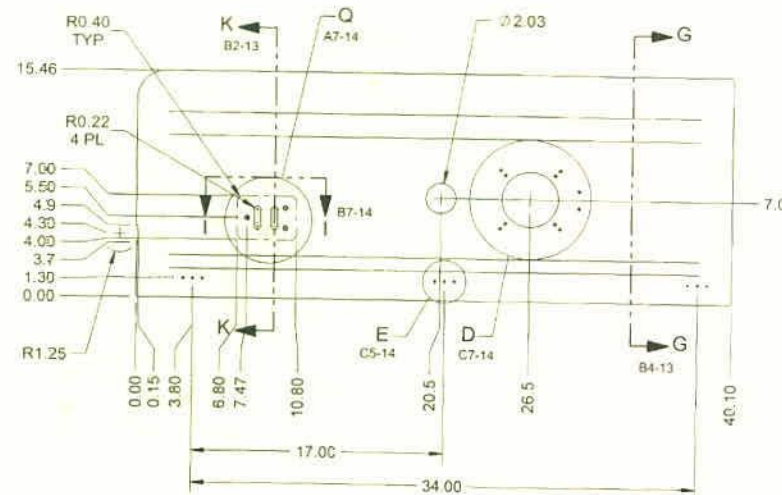
NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4635	SHEET 11 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS	NTS
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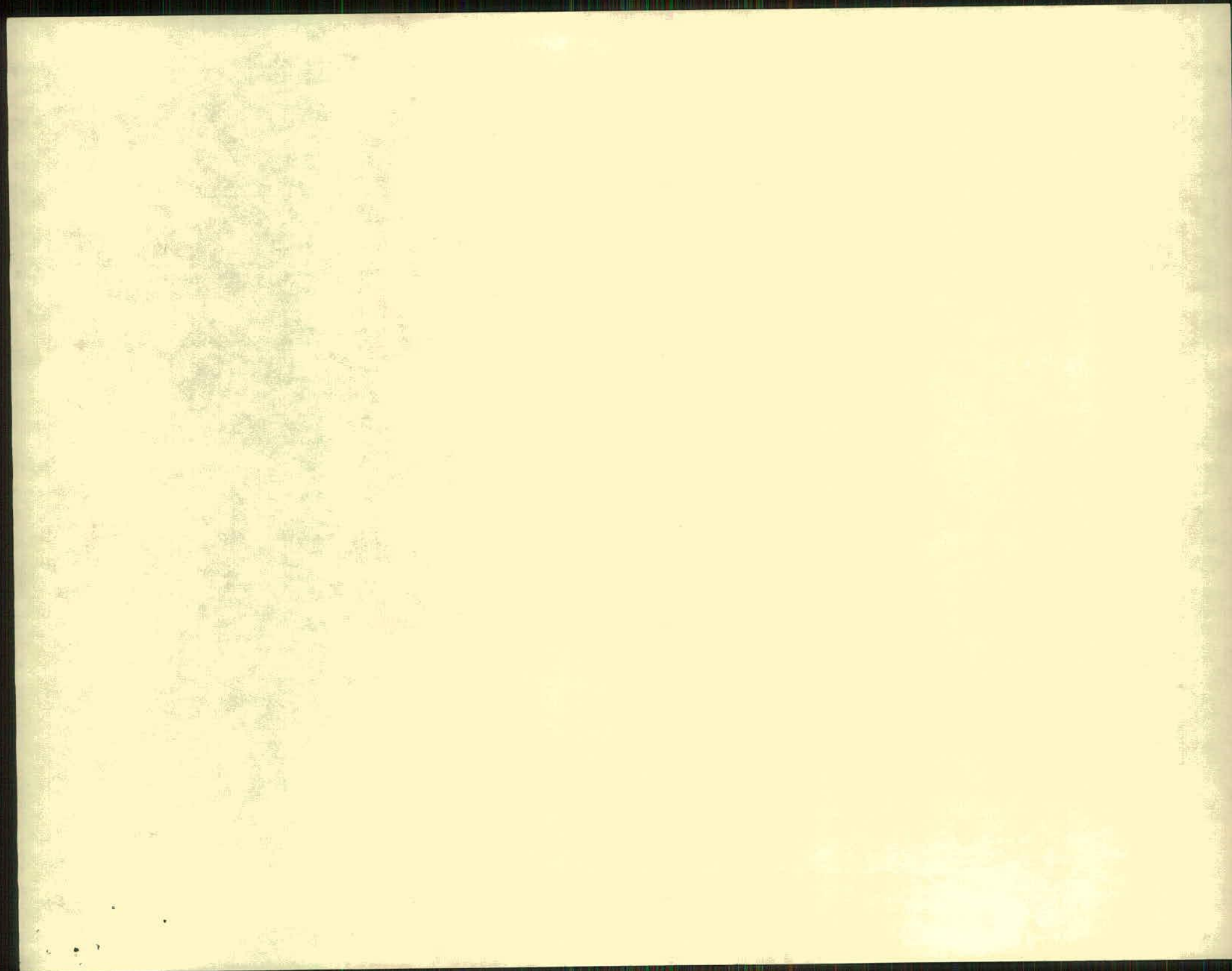


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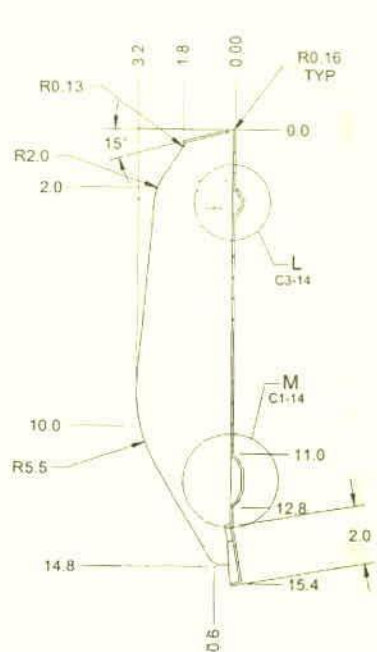
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-4 PER TOOL DT9842
- 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-4 RH, AFT CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 12 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
DATE	12.07.25	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE (OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD)</small>	

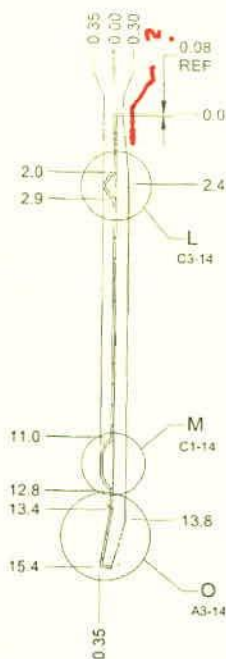


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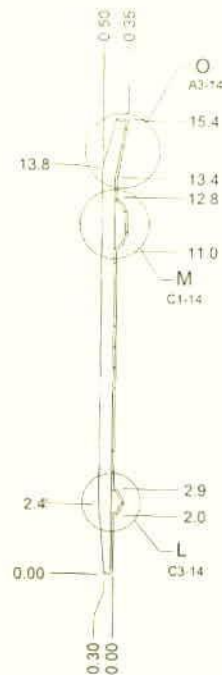
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

B3-9
B3-10



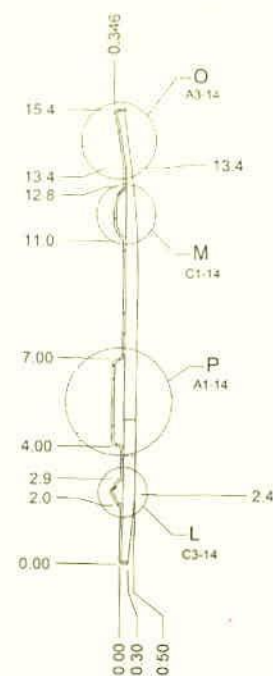
SECTION B-B
SCALE 2X

B7-9
B7-10



SECTION G-G
SCALE 2X

B4-11
B4-12



SECTION K-K
SCALE 2X

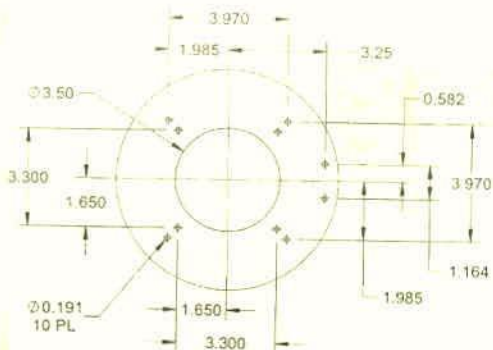
C6-12

12 2012-11-05
WHP

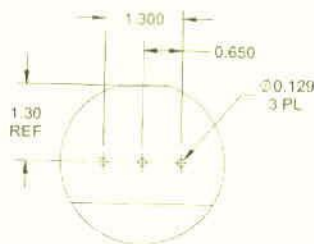
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DRAWN	RF		
CHECKED	RF	DRAWING NO. D4635	REV. A
MFG. APPR.	RF	TITLE OUTBOARD CEILING PANELS	SHEET 3 OF 14
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DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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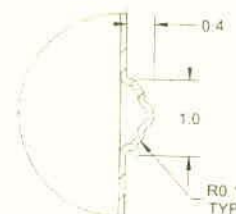
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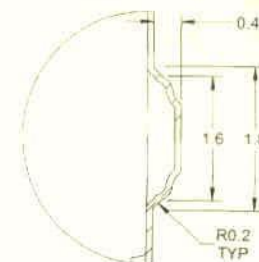
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B4-9
B3-10
B5-11
B5-12



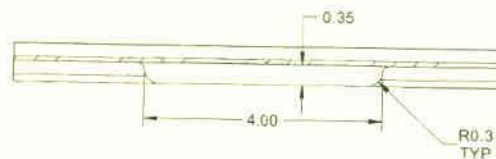
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C7-9
B6-10
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B5-12



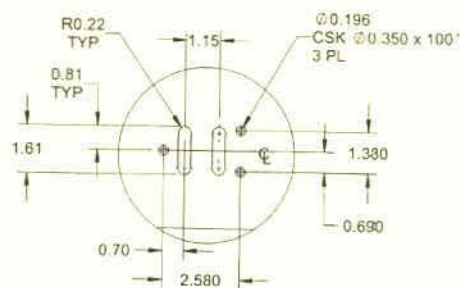
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C5-13
C7-13



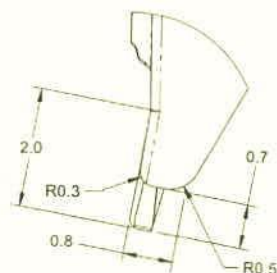
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C7-13



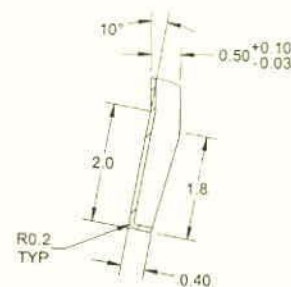
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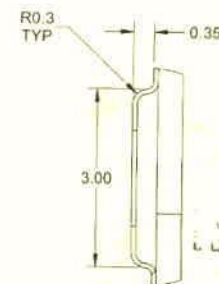
DETAIL Q
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C5-12



DETAIL N
SCALE 2X
B2-9

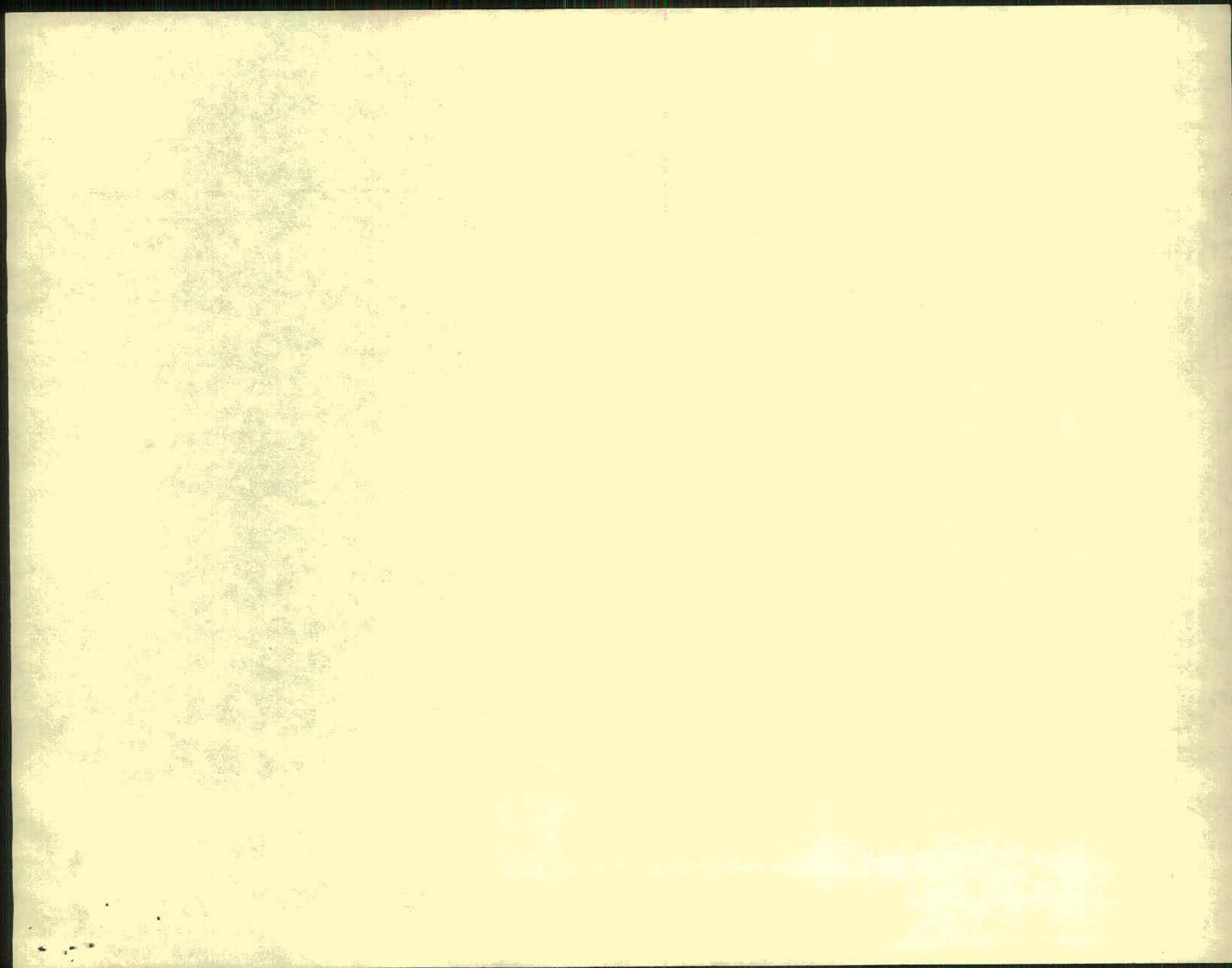


DETAIL O
SCALE 2X
D2-13
D3-13
B5-13



DETAIL P
SCALE 4X
C2-13

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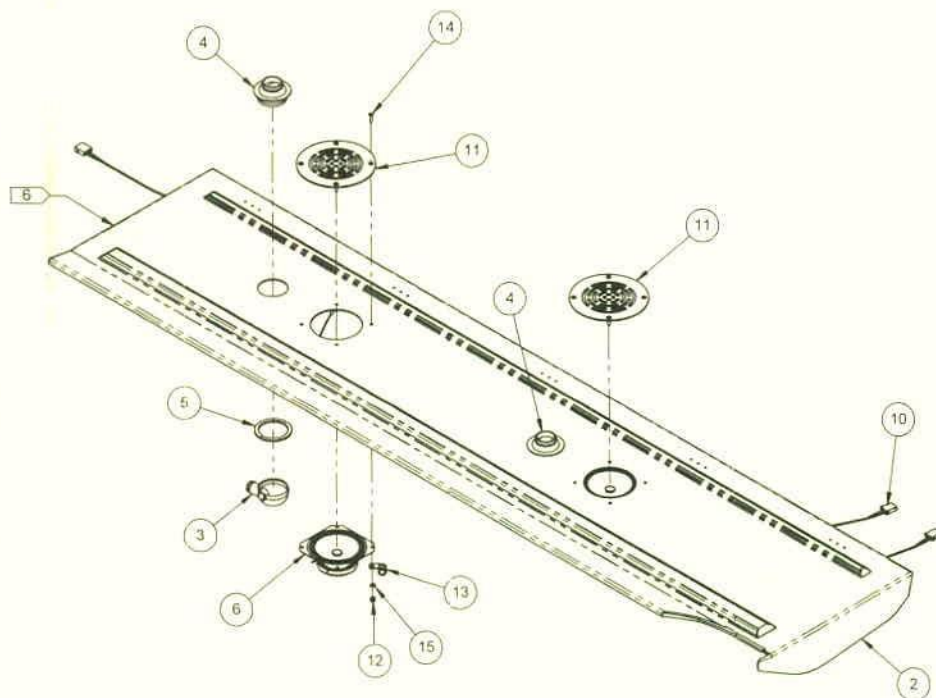
8 7 6 5 4 3 2 1

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9

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	D4652-3	MOUNTING NUT
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANDYARD
8	1	D4728-041	LH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-043	LH SPEAKER #2 HARNESS ASSEMBLY
10	1	D4728-059	CABIN LIGHT HARNESS
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT
13	6	MS21919WDG8	CLAMP
14	8	MS24693-BB51	SCREW
15	8	NAS1149DN832J	WASHER
16	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

D

C

B

A

PRELIMINARY ISSUE

12.11.30

D4635-041 LH, FWD CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.8 lbs
- 8) INSTALL D4728-041/-043/-059 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

PB3	ADDED D4635-141/-142/-143/-144 (ZN B4-8, B4-10, B4-11, B4-12); REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADDED D4732-41 (ZN B5-8)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV	DESCRIPTION	BY	DATE
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MFG. APPR		D4635	SHEET 1-OF 18
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8

7

6

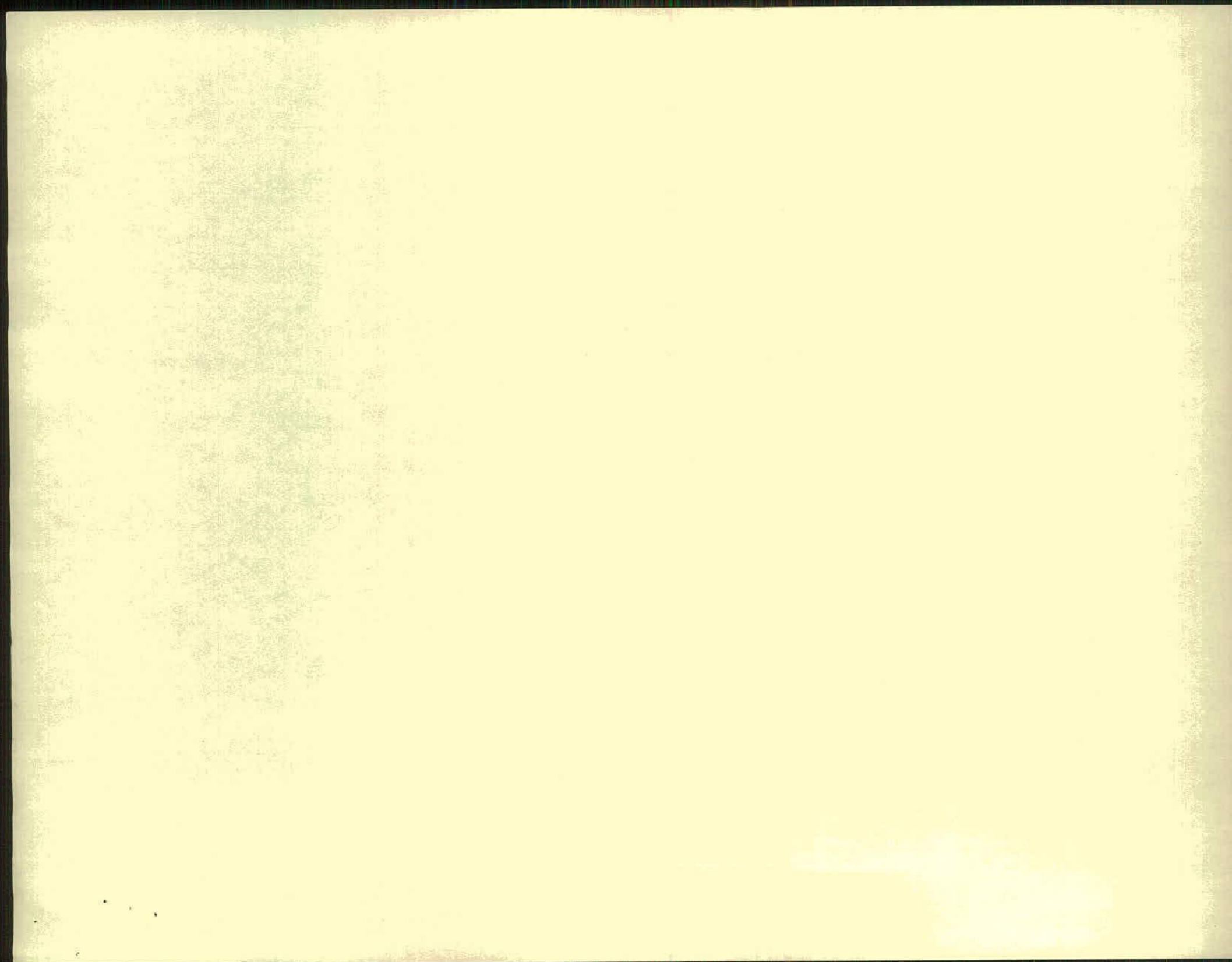
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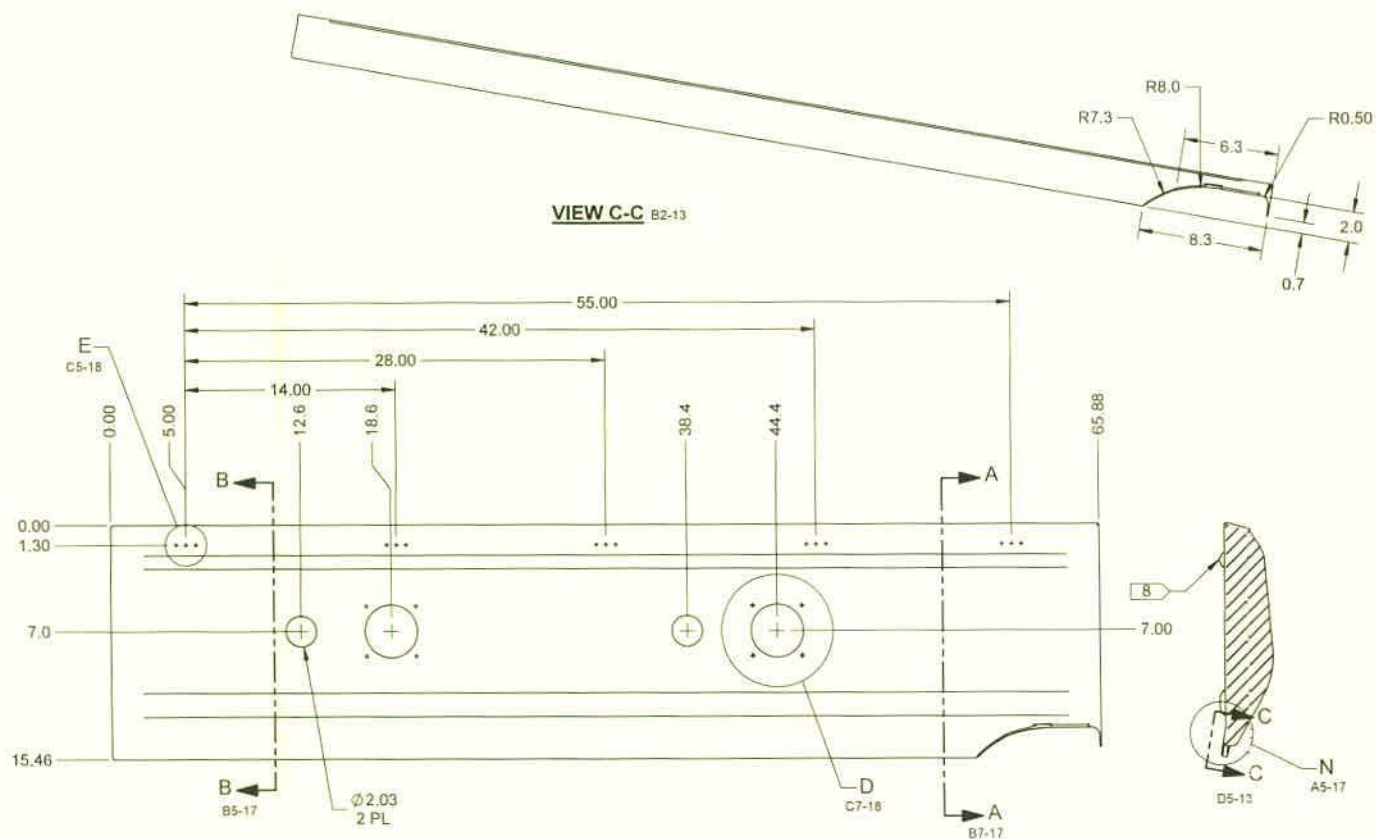
4

3

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1





NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK.
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.29 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

PRELIMINARY ISSUE

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SECTION A-A
SECTION A'-A' OPPOSITE
SCALE 2X

AUXILIARY VIEW R-R
SECTION A'-A' OPPOSITE
SCALE 2X

SECTION B-B B7-13
SCALE 2X B7-14

AUXILIARY VIEW S-S
SECTION A'-A' OPPOSITE
SCALE 2X

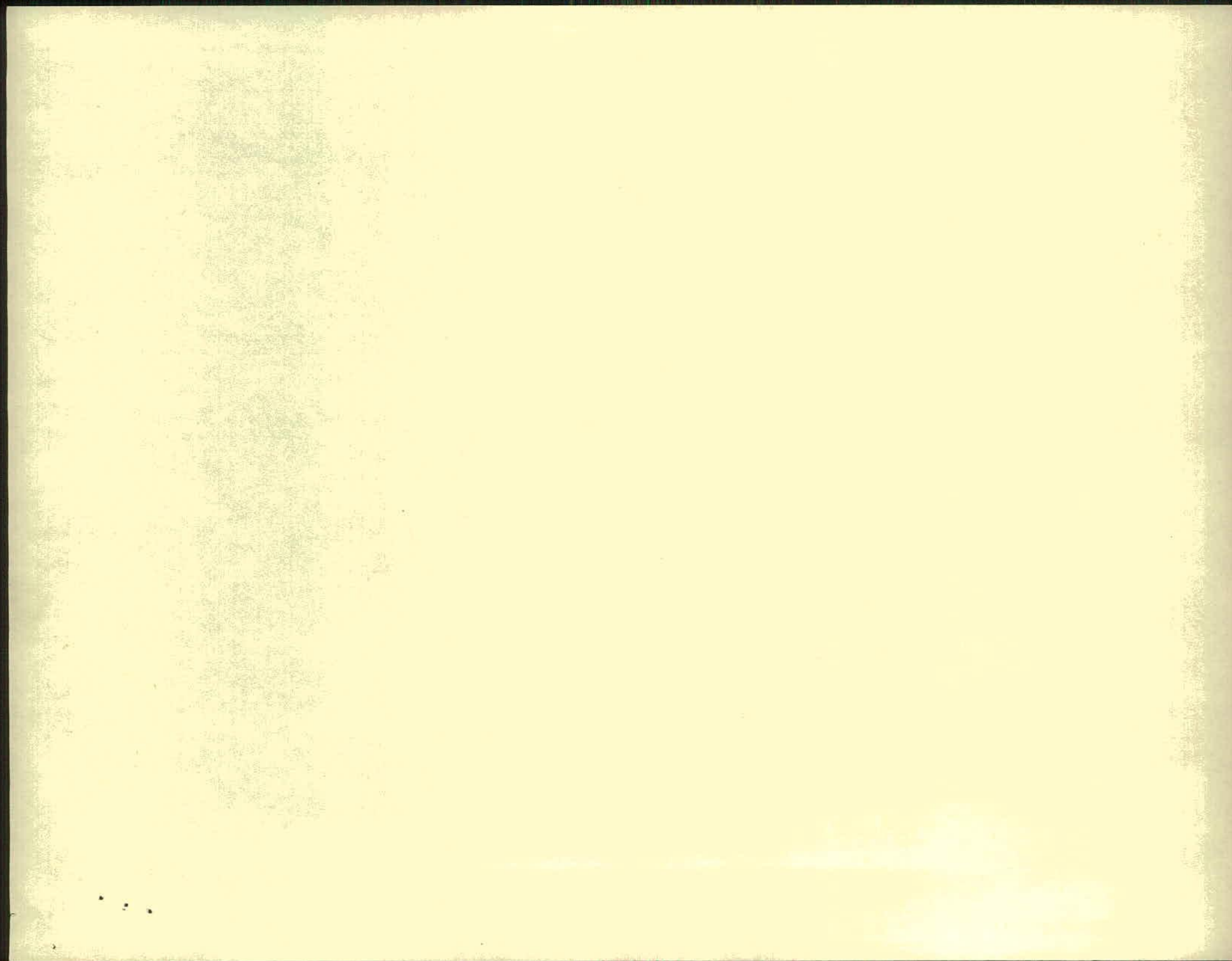
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SCALE 2X B4-16

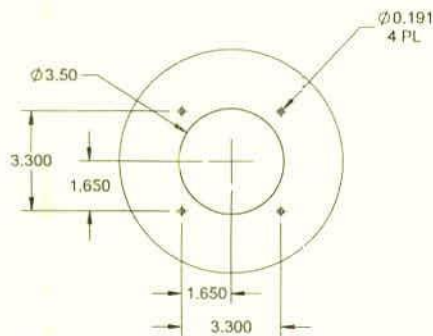
SECTION K-K C6-16
SCALE 2X

PRELIMINARY ISSUE

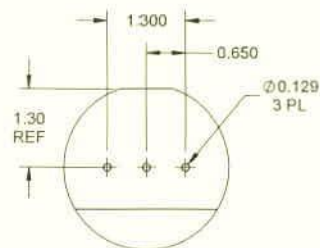
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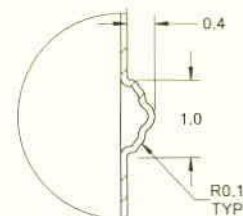




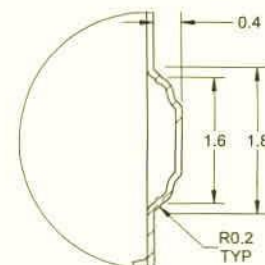
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



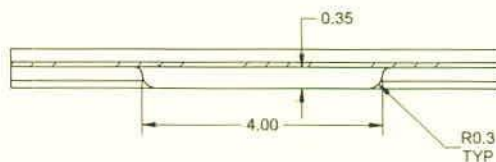
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C7-13
B5-14
C8-15
B5-16



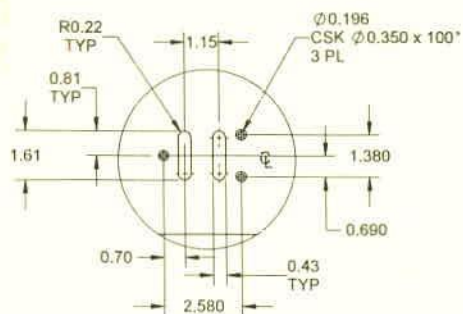
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B4-17
C5-17
C7-17



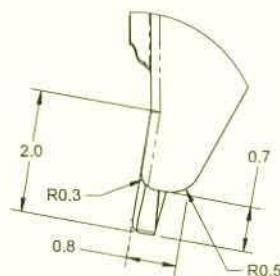
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C7-17



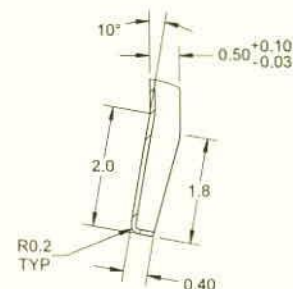
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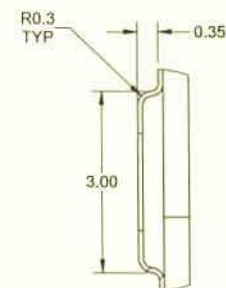
DETAIL Q
SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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